

Date: Wednesday, 5/31/2006 7:32:01 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FOLDING STEP WELDMENT LH
Job Number :	27268		
Estimate Number :	10463		
P.O. Number :	N/A	Part Number :	D3388041
This Issue :	5/31/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3388 REV A
First Issue :	N/A	Project Number :	N/A
Previous Run :	27086	Drawing Revision :	A
		Material :	N/A
Written By :	See Comment Below	Due Date :	6/18/2006
Checked & Approved By :	KJ 06.05.31 W	Qty:	5
Comment :	Est. B 05.06.10 Added Step 11 KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 D2622-120C extrusion 8
 Batch: B27077

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388
 2-Deburr and bevel ends for welding

PE 06.07.04 5
 PE 06.07.04 5

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 206 Step Endplate
 Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B24402

PE 06.07.04 5

4.0	D33871	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Arm
 Pick:

Qty	Part Number	Description	Batch
2	D3387-1	Arm	B27288

PE 06.07.04 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: ~~A~~

Grind end cap welds flush

FF 06-07-06

(P70)

5

(P70)

5

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:07:08

(5)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

am 06-07-19

(5)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FC 06 07 20

(5)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

06-08-01

(5)

10.0 D2808 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D2808	Spacer	B27564

B27564

SAD 06:08:01

(5)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

SAD 06:08:01

(5)

5.1 QC5/QC9 Inspect weld

06-07-06

06/07/06

(5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
	6.1	QC 3 Inspect Abalone.	Z	06.07.10	5	U	}	
	6.2	weld last end cap AS per Dwg D3388: Inspect ^{for} conformity ^{subject}	PC	06.07.18	5			
	6.3	grind flush	FF	06.07.18	5			
	6.5	Abalone cap AS per QSI 005 4.1: Touch-up abalone as req'd.	2/M	06.07.19	5			
	6.4	QC 5/9 Inspect work: welds.	PC	06.07.08	5			06.07.19
		permanent change						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/08/09 (5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-4

06-08-08 (5)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/09 (5)

Job Completion



06-08-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

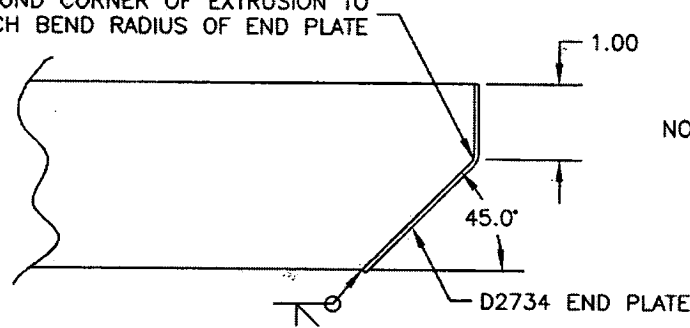


05-03-11

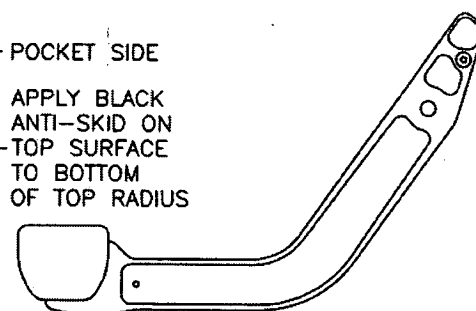
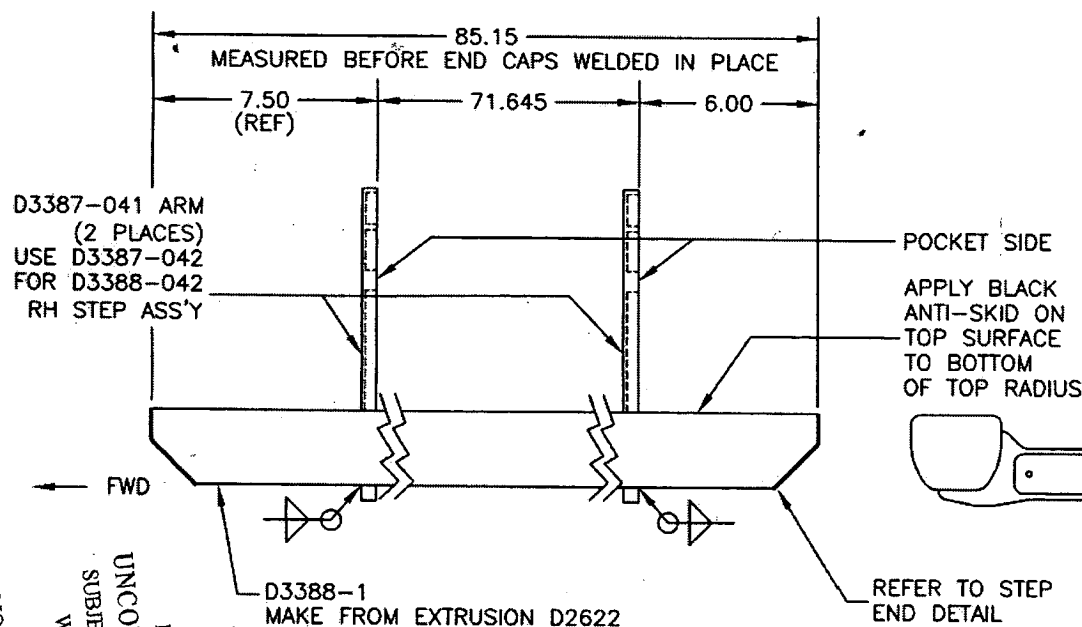
RELEASED

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 27268

D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
05-01-20	05-01-20	NEW ISSUE	
CHECKED	APPROVED	DRAWING NO. D3388	SHEET 1 OF 1
DATE	TITLE	STEP WELDMENT	SCALE
05.01.20			NIS